



5616 REPAIR CLAMP

INSTALLATION GUIDE



*A standard feature of the **5616** (Style 1) ROBAR Repair Clamp is its ease of installation. All Robar Repair Clamps are pre-formed at the factory, allowing for easy installation.*

1. Remove the clamp from its box. Ensure it has the required outside diameter for the desired application. Visually inspect the repair clamp to make certain there are no missing nuts, washers, or lifter bars.
2. Open the clamp by backing off the nuts to the end of the bolts. To avoid loss or misplacement of components, do not completely remove the nuts.
3. Clean the pipe over the entire circumference where the clamp is to be installed. Be sure that there is no foreign debris (pebbles or dirt) on the clamp gasket or pipe. Lubricate the entire clamp gasket with a potable, NSF certified lube. ROBAR recommends SLIKSTYX.
4. A minimum of 4" of clamp is recommended beyond each side of the repair area. (i.e. If a 4" longitudinal crack is being repaired, a 12" long clamp is recommended). Also, a small hole can be drilled at each end of the crack to prevent it from spreading.
5. Slide the bolts under and around the pipe until the bolts point upwards.
6. Grasp the lifter bar on the bolts and pull it up and out until it snaps into position over the receiver lugs. Ensure that the gasket is not folded over. Tighten the nuts slightly by hand to prevent the lifter bar from lifting.
7. Tighten the nuts, using a torque wrench, evenly and incrementally. Start in the center, and move outward. Torque each nut to 80 ft. lbs.

**** the pressure rating and length of service of the repair clamp is influenced by the type of repair, extent of damage, condition of pipe, surrounding environmental conditions and installation workmanship ****

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